

Date: Tuesday, 19/08/2008 4:05:14 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | | |
|-----------------------|--|----------|------------------|------------------|---------------|-----|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : WEARPAD | | |
| Job Number | : 41463 | | | Part Number | : D356411 | | |
| Estimate Number | : 12785 | | | Drawing Number | : D3564 REV D | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 19/08/2008 | S.O. No. | : | Drawing Revision | : D | | |
| Prsh Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : SMALL /MED FAB | Due Date | : 29/08/2008 | | |
| Previous Run | : 40191 | | | Qty: | 20 | Um: | Each |
| Written By | : | | | | | | |
| Checked & Approved By | : JLD 08-8-19 | | | | | | |
| Comment | : Est Rev:A New Issue 07-03-08 ec | | | | | | |
| | : Est Rev:B As per Rev C 07-07-09 JLM | | | | | | |
| | : Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M304S16GA | 304/316 Sheet .063 |
| Comment: Qty.: 1.4805 sf(s)/Unit Total : 29.6100 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 108724 RB 8-8-27 | | |
| 2.0 | WATER JET | FLOW WATER JET |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)**** Dwg Rev: <u>D</u> RB 8-8-27 Prog Rev: <u>D</u> | | |
| 2-Deburr if necessary RB 8-8-27 | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE RB 8-8-27 |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK RB 8-8-27 <i>checked</i> |
| Comment: SECOND CHECK | | |
| 5.0 | BRAKE NC | NC BRAKE |
| Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41463

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/08/08 X22 over OS

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat M108709
Weld hardcoat as per Dwg D3437

EL 8-9.4 X22

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/04 X22 over OS

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 06/09/04 X22

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(22)

START TIME: 6:45
OVEN TEMPERATURE: 320°
FINISH TIME: 7:15

EL 08/09/08

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/09/08

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP-19

(22)

EL 08/09/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:05:14 PM
User: Julie Lecocq

Process Sheet

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Drawing Name: WEARPAD

Job Number: 41463

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/09 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



-mf 08-09-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

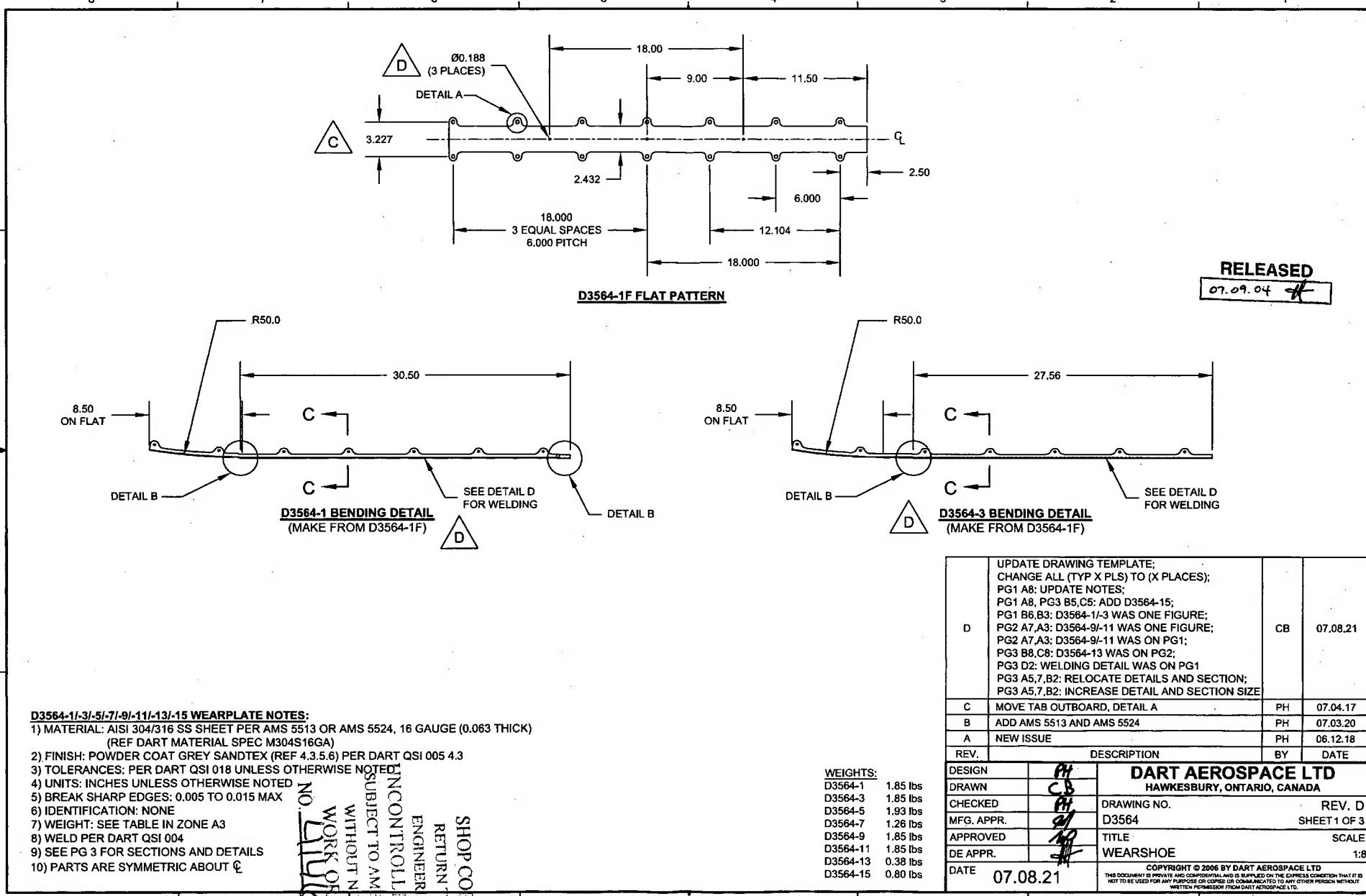
| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 414103 |
| Description: Wearshoe | Part Number: | D3564-11 |
| Inspection Dwg: D3564 Rev: D | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

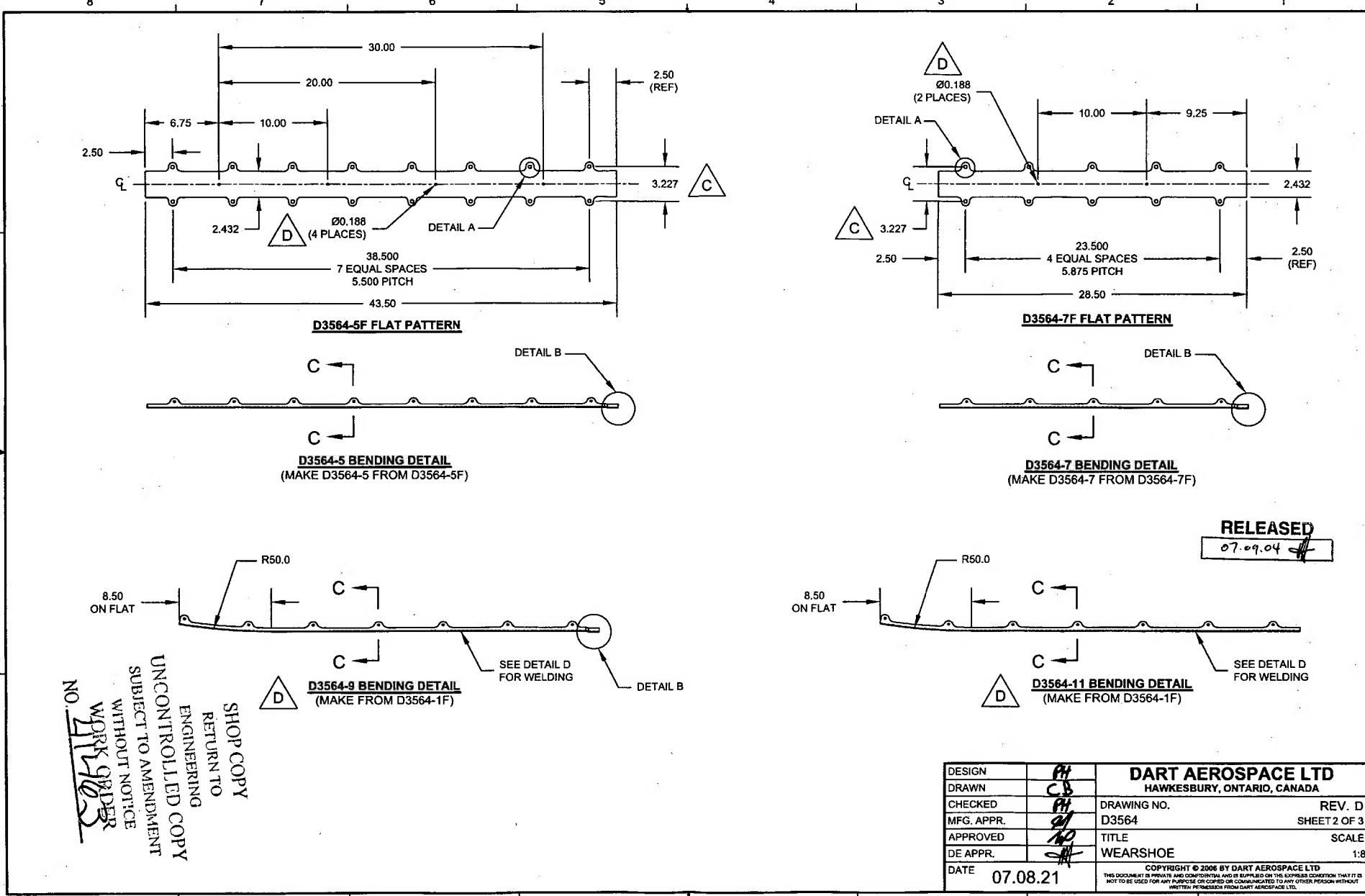
X First Article Prototype

| | | | | | |
|--------------|-----------|-------------|----------|---------------------|-----|
| Measured by: | <u>VB</u> | Audited by: | <u>C</u> | Prototype Approval: | N/A |
| Date: | 8-8-27 | Date: | 08/08/28 | Date: | N/A |

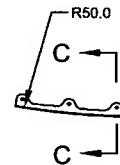
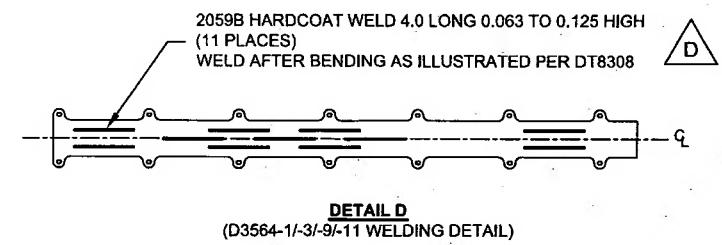
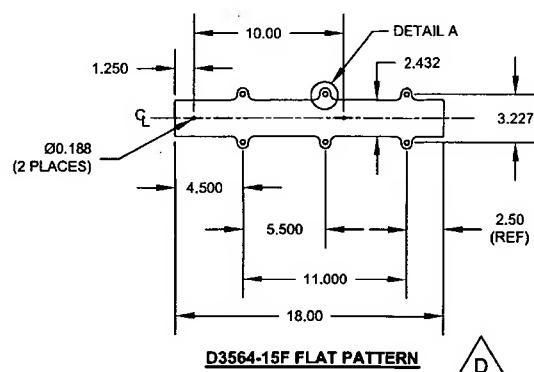
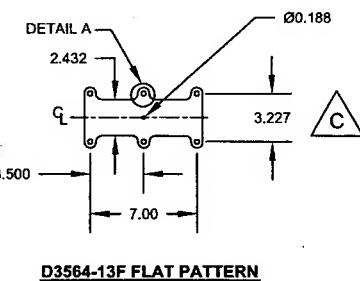
| Rev | Date | Change | Revised by | Approved |
|------------|-------------|-----------------|-------------------|-----------------|
| A | 07.09.06 | New Issue | KJ/JLM | |
| B | 07.11.23 | Dwg Rev updated | KJ/EC/DD | JK |



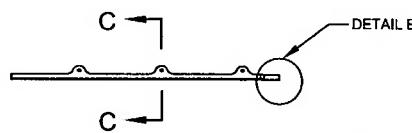
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8 7 6 5 4 3 2 1

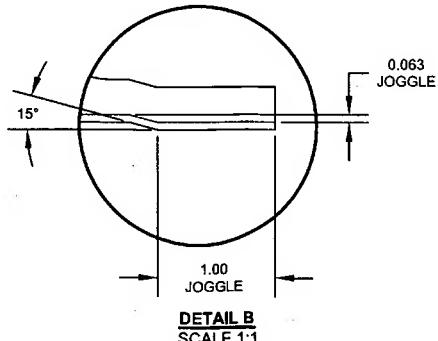
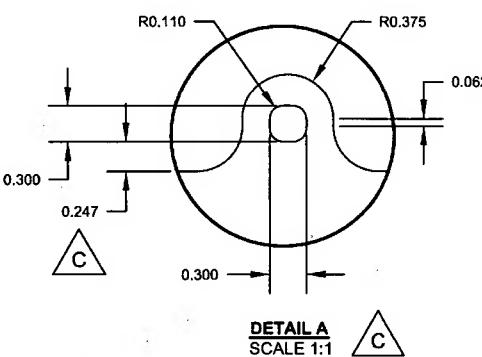
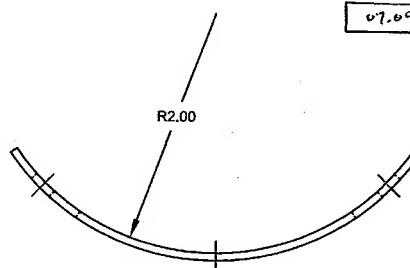


D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



RELEASED

07.09.04



| | | |
|------------|----------|-----------------------------|
| DESIGN | P4 | DART AEROSPACE LTD |
| DRAWN | C8 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | P4 | DRAWING NO. |
| MFG. APPR. | S1 | D3564 |
| APPROVED | AD | REV. D |
| DE APPR. | | SHEET 3 OF 3 |
| DATE | 07.08.21 | TITLE WEARSHOE |

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